

Work Order ID 166352***166352***

Page 1

Monday, September 18, 2017 8:52:42 AM

Item ID: D412-698-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Support - V Block

Start Date: 9/18/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/26/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: SEP 18 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

F

SEP 17 2017

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D412-698-015 CHG001

2

DAS
28
9-89

SEP 19 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

DAS
6
9-89

SEP 19 2017

DAS
27
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.06

Quality Control

2

DAS
28
9-89

SEP 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Work Order ID 166352***166352***

Page 2

Monday, September 18, 2017 8:52:42 AM

Item ID: D412-698-015 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Support - V Block
Start Date: 9/18/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/26/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging					2	DAS 28 9-89	SEP 19 2017	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-015 Location: FG022								
140	QC21- Final Inspection - Work Order Release	0.00							
140	QC	0.20							
Quality Control									

17/9/2017

SEP 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

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166352

D412-698-015

Required Qty: 2.00

27-89

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 2

Work Order ID: 166352

166352

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 9/18/2017

Required Date: 9/26/2017

Start Qty: 2.00

Required Qty: 2.00

D3201-3 Manufactured No

110 Each

8.0000

1 2

D3201-3

Angle

**

SEP 19 2017

DAS 27
9-89

Location

Loc Qty

Loc Code

ST023

8

140937

1

158432

3

163468

4

D3201-4 Manufactured No

110 Each

9.0000

1 2

D3201-4

Angle

**

SEP 19 2017

DAS 27
9-89

Location

Loc Qty

Loc Code

ST023

9

155564

1

158430

4

164723

4

MS21042L3 Purchased No

110 Each

1,487.000

12 24

MS21042L3

Nut

**

SEP 19 2017

DAS 27
9-89

Location

Loc Qty

Loc Code

FP001

44

m135945

44

GA

308

m134360

102

M136665

206

OVER007

500

m138408

500

ST303

635

m137495

12

m138230

500

m138326

123

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____									

Picklist Print

Monday, September 18, 2017 8:52:45 AM

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Work Order ID: 166352

166352

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support - V Block

Start Date: 9/18/2017

Required Date: 9/26/2017

Start Qty: 2.00

Required Qty: 2.00

MS24693-S277

Purchased

No

110

Each

66.0000

12

24

MS24693-S277

Screw

**

SEP 19 2017

DAS 6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST286

66

M136851

16

M137178

50

NAS1149D0332J

Purchased

No

110

Each

1,337.000

12

24

NAS1149D0332.J

Washer

**

SEP 10 2017

DAS 6 27
9-89 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

186

m136643

186

ST260a

1000

m138238

1000

ST264

151

m137412

12

m137963

139

12
12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : 8/2/2018		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition 85				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval ,	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		NAS1149D0332J	WASHER (AN960JD10L)
	2	NAS1149D0516J	WASHER (AN960JD516L)
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Page 1

Quality Control

2 SEP 19 2017

L **DAS** **SEP 19 2017** **DAS**
27
9-86

2 DAS SEP 19 2017
28
9-8



Transport Canada Transports Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

Eagle Copters Ltd.
823 McTavish Road N.E.
Calgary, Alberta
Canada T2E 7G9

Number: SH92-43

Issue No.: 5

Approval Date: August 26, 1992

Issue Date: September 14, 2007

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

BELL 204B, 205A, 205A-1, 205B, 212, 214B, 214B-1, 412,
412 CF, 412 EP

Canadian Type Certificate or Equivalent:

BELL 205B H-104
BELL 214B, 214B-1 H-80
BELL 212, 412, 412 CF, 412 EP H-86
BELL 204B, 205A, 205A-1 H1SW

Description of Type Design Change:

Serviceability Kit: Aux Cowl latches, cockpit door wear pads,
cabin door handle, sliding door roller system and automatic
door opener kit

**Installation/Operating Data,
Required Equipment and Limitations:**

Configuration 1:

Installation of Serviceability Kit to be done in accordance with DOT approved Aero Design Ltd.,
Document Control List A-85-DCL1, Revision 1, dated 27 January 1997, or later approved Revision.

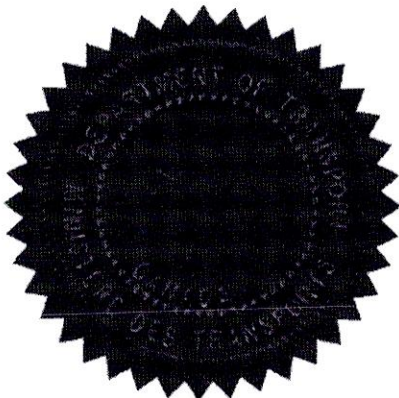
Configuration 2:

Installation of Door Modification Kits to be done in accordance with Transport Canada (TC) approved
Dart Aerospace Ltd. Installation Instructions IIN-D412-698, Revision D or later TC approved revision.

Inspection of Door Modification Kits is to be performed in accordance with Dart Aerospace Ltd.
Instructions for Continued Airworthiness ICA-D412-698, Revision 3 or later TC accepted revision.

-END-

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein.
Prior to incorporating this modification, the installer shall establish that the interrelationship between this
change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the
modified product.




Greg Oucharek
Senior Aircraft Certification Engineer
For Minister of Transport

Canada



Transport Canada Transports Canada

Department of Transport

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Aircraft/Engine Type or Model:

BELL 204B, 205A, 205A-1, 205B, 212, 214B, 214B-1, 412,
412 CF, 412 EP

Canadian Type Certificate or Equivalent:

BELL 205B H-104
BELL 214B, 214B-1 H-80
BELL 212, 412, 412 CF, 412 EP H-86
BELL 204B, 205A, 205A-1 H1SW

Description of Type Design Change:

Serviceability Kit: Aux Cowl latches, cockpit door wear pads,
cabin door handle, sliding door roller system and automatic
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**Installation/Operating Data,
Required Equipment and Limitations:**

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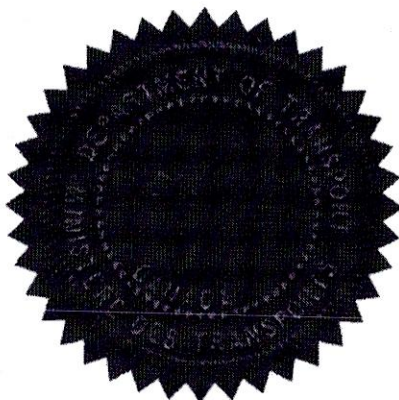
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Greg Oucharek
Senior Aircraft Certification Engineer
For Minister of Transport

Canada